

Work Order ID 82628

82628

Page 1

April-04-12 10:48:54 AM

Item ID: D4306-044 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Rib Assembly, RH
 Start Date: 04/04/2012 Start Qty: 2.00 ***2*** Cust Item ID:
 Required Date: 30/04/2012 Req'd Qty: 2.00 ***2*** Customer:
 Reference:

Approvals: Process Plan: MLT Date: 12/04/04 Tooling: _____ Date: _____
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____
 Run Start ***NR1***
 Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4306	C								

100 Weld per dwg A/R S.S. rod Batch: M121602 0.00

100

Large Fab

Large Fab

Memo

0.00

1- Cut tube 52"

2- Bend tube with manuel pipe bender as per DT9567

*** Make line at 10.00" and use jig for other lines, and ensure seam in place on side of tube when bending***

3- Trim access tube material to finish size and cut notch as per dwg D4306-4

4- Drill and chamfer holes as per dwg D4306-4 using DT9710

5- weld bushing as per dwg D4306

6- grind welds flush

① SAD 12-07-19

SD/CC 12-7-20

110

QC6- Inspect dimensions to drawing

0.00

110

QC

Quality Control

Memo

0.00

1/x 12-7-23 DAS 24 6-88

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 82628

April-04-12 10:48:54 AM

82628

Page 2

Item ID: D4306-044
Revision ID:
Item Name: Rib Assembly, RH

Accept

N900040100

Setup Start ***NS1***
Stop ***NS2***


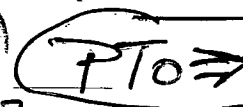

Start Date: 04/04/2012 Start Qty: 2.00 ***2***
Required Date: 30/04/2012 Req'd Qty: 2.00 ***2***


Cust Item ID:
Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***
Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* QC Quality Control	QC10- Inspect visual per QSI004- ground welds QC 9  Memo	0.00 0.00				1x	0	DAS 24 9-08 12.7.23	
130 *130* Packaging Packaging	Identify as per dwg & Stock Location: WA Memo	0.00 0.00				1x		DAS 24 9-08 12.7.23	
140 *140* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							12/7/24  MLJ 12/07/23

W/O: 82628		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
12-7-23	120	Change to QC9	CPC				

Part No: D4306-044 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

April-04-12 10:48:58 AM

Page 1

Work Order ID: 82628

82628

Parent Item: D4306-044

D4306-044

Parent Item Name: Rib Assembly, RH

Start Date: 04/04/2012

Required Date: 30/04/2012

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:A 11.01.20 new issue DD verf:EC
11.03.03 AS PER DWG REV.C DD verf:EC

IPP Rev:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3759-1		Manufactured	No			100	Each	231.0000	4	8			
D3759-1									**			CC 12-7-20	
Bushing													

Location

Loc Qty

Loc Code

WA

203

B-83464 →

(4X)

79213

203

WA005

28

66489

1

74783

27

M304TS0.750W.049

Purchased

No

100

f

556.4351

4.166

~~8.770526~~

4.3853

M304TS0 750W 049

304 SQ Tube .75x.75x.049W

**

SAP

12-07-20

Location

Loc Qty

Loc Code

MAT018

248.3105959

117775

93.6739

118472

47.1990839

118880

0.2736

119147

76.4906

119643

17.1154

120494

13.5580119

MAT034

285.197927

117337

1.8507

121087

283.347227

WA035

22.92654

118184

22.92654

71121898

4.3853

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

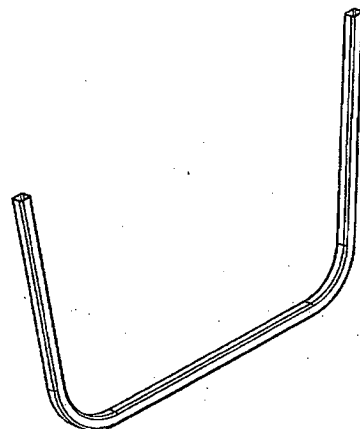
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

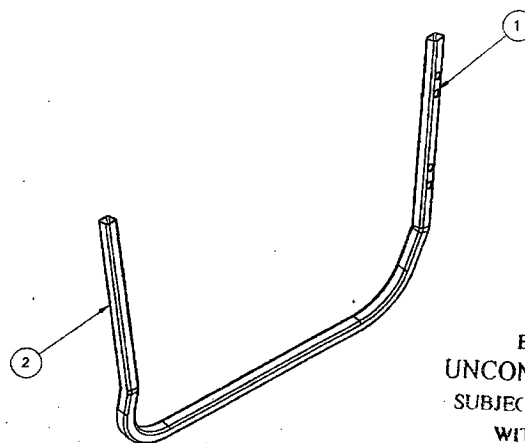
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

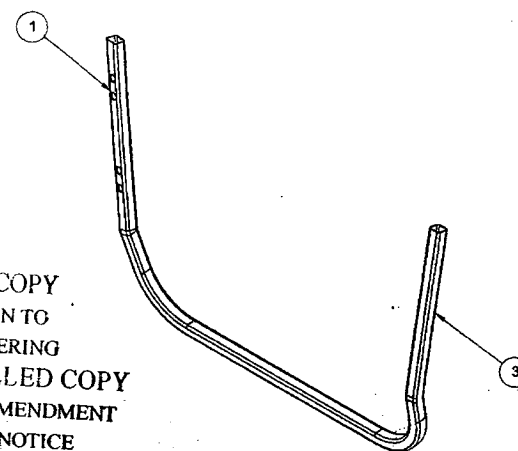
ITEM	QTY -043	QTY -044	QTY -045	P/N	DESCRIPTION
	X			D4306-043	RIB ASSY, LH
		X		D4306-044	RIB ASSY, RH
			X	D4306-045	RIB ASSY
1	4	4	4	D3759-1	BUSHING
2	1			D4306-3	RIB
3		1		D4306-4	RIB
4			1	D4306-5	RIB



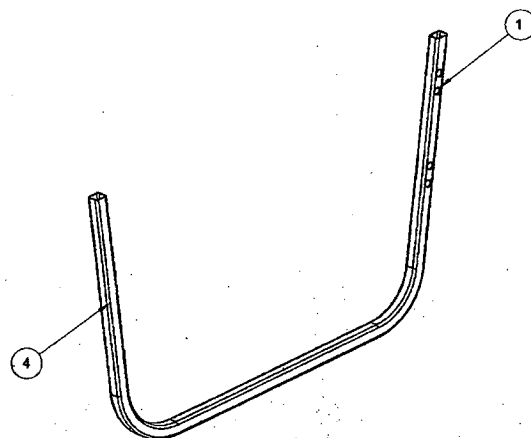
D4306-1 RIB



D4306-043 RIB ASSY, LH



D4306-044 RIB ASSY, RH



D4306-045 RIB ASSY

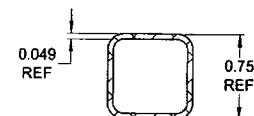
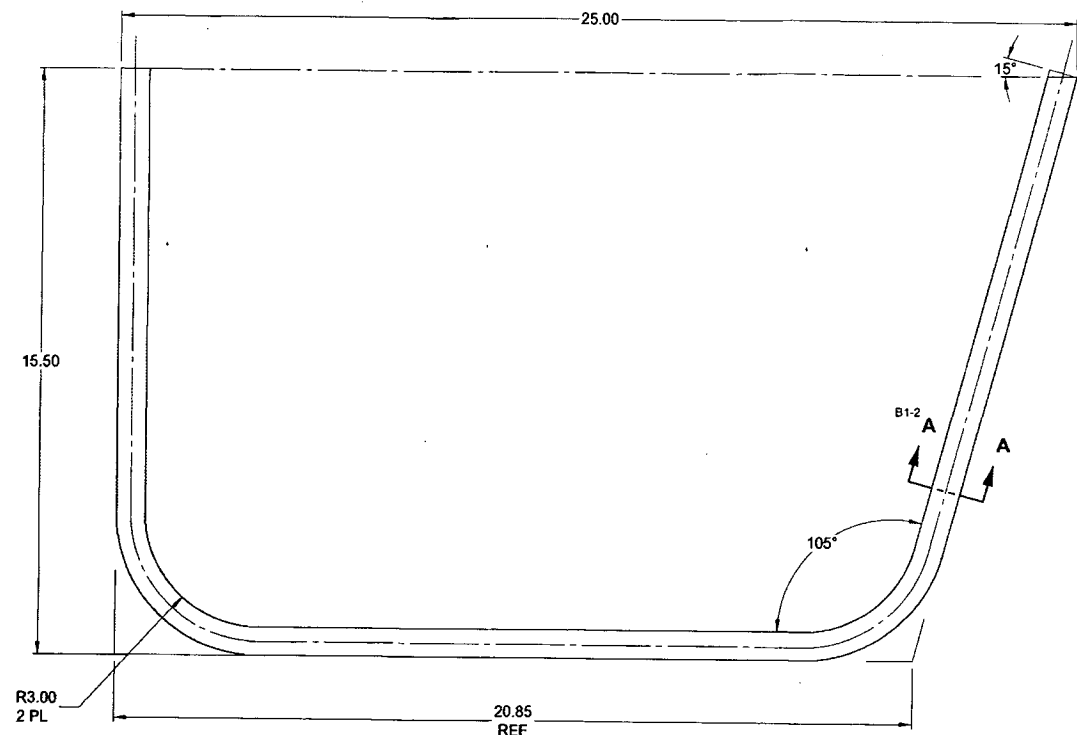
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO. 82628 MJS
12/04/04

RELEASED
2011-03-19

REV.	DESCRIPTION	BY	DATE
C	REFERENCE LENGTH CHANGED TO 52.0" FOR D4306-3, D4306-4 RIBS (A7-4-6); INCREASED LENGTH OF D4306-3, D4306-4 RIBS BY 0.65" (C7-4, C8-4, C1-6, C2-6); CHANGED CUT ANGLE FROM 19° TO 22° (B8-4, B1-6); ADDED 4.50" REF DIM ON D4306-043/044 (B6-3, B3-5)	SC	11.02.09
B	D4306-043, D4306-044, D4306-045 ADDED	SC	10.12.17
A	NEW ISSUE	CP	10.11.29
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CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	11.02.09	REV. C SHEET 1 OF 8 SCALE NTS	

82628



SECTION A-A B4-2

8 D4306-1 RIB

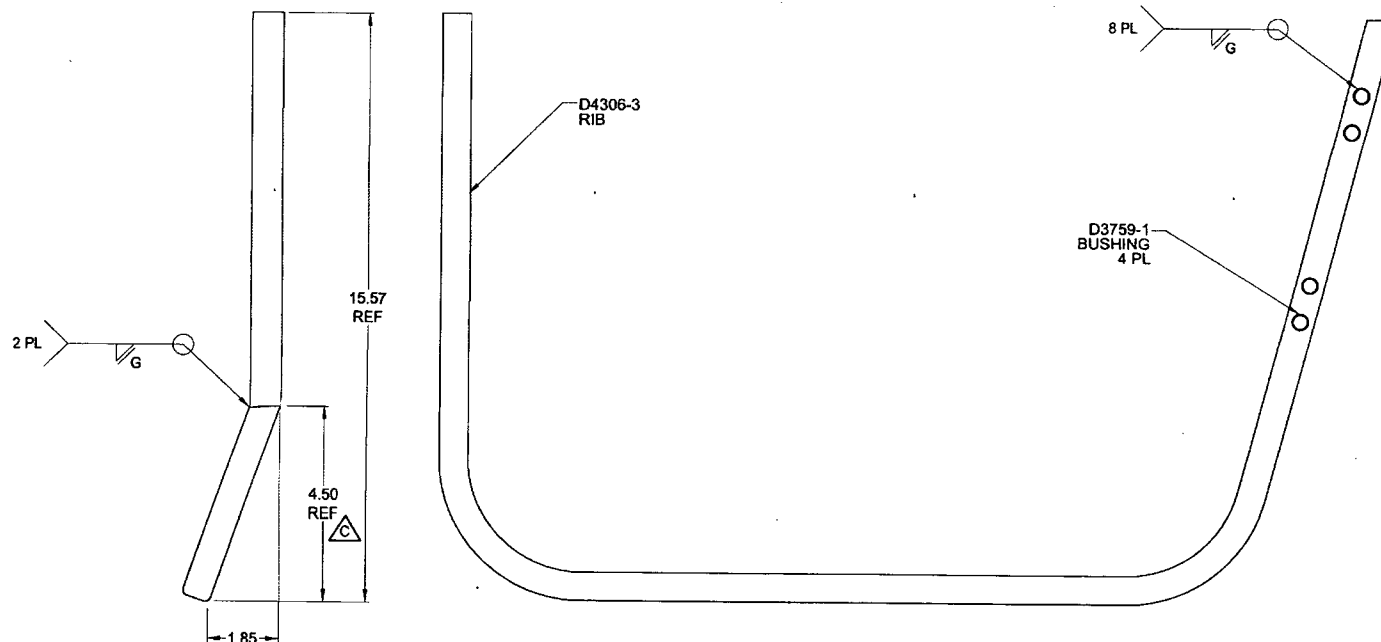
RELEASED
2011-02-24
WAD

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.049 WALL
REF DART SPEC. M304TS0.750W.049
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.78 lbs
- 8) TUBE FLAT LENGTH 50.0 REF

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D4306-043 RIB ASSY, LH

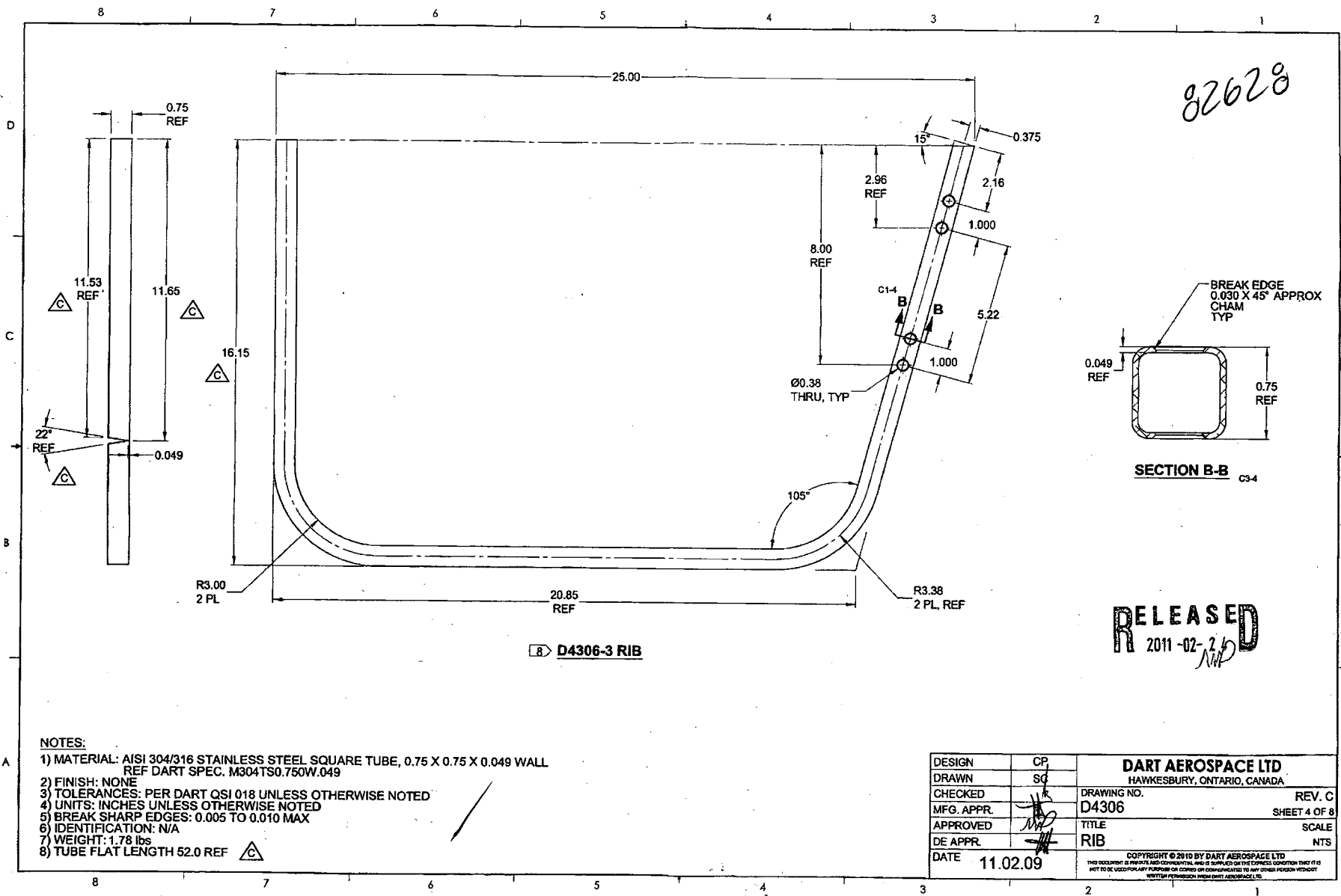
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2011-02-24
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NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.78 lbs
- 8) WELDING: PER DART QSI 004

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SECTION B-B C3-4

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2011-02-21

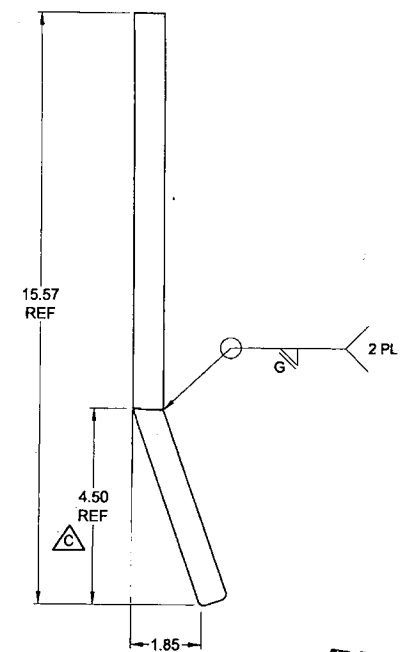
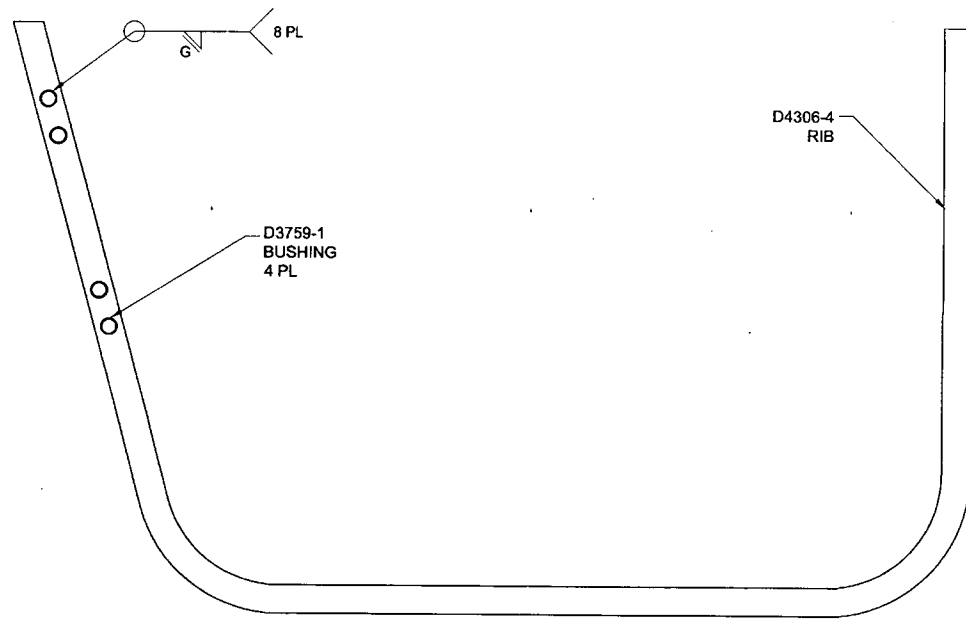
D4306-3 RIB

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.049 WALL
REF DART SPEC. M304TS0.750W.049
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.78 lbs
- 8) TUBE FLAT LENGTH 52.0 REF

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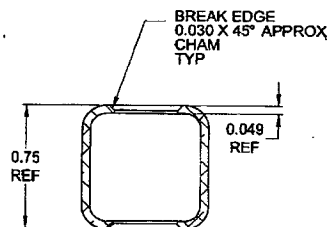
D4306-044 RIB ASSY, RH

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2011-02-24
WJ

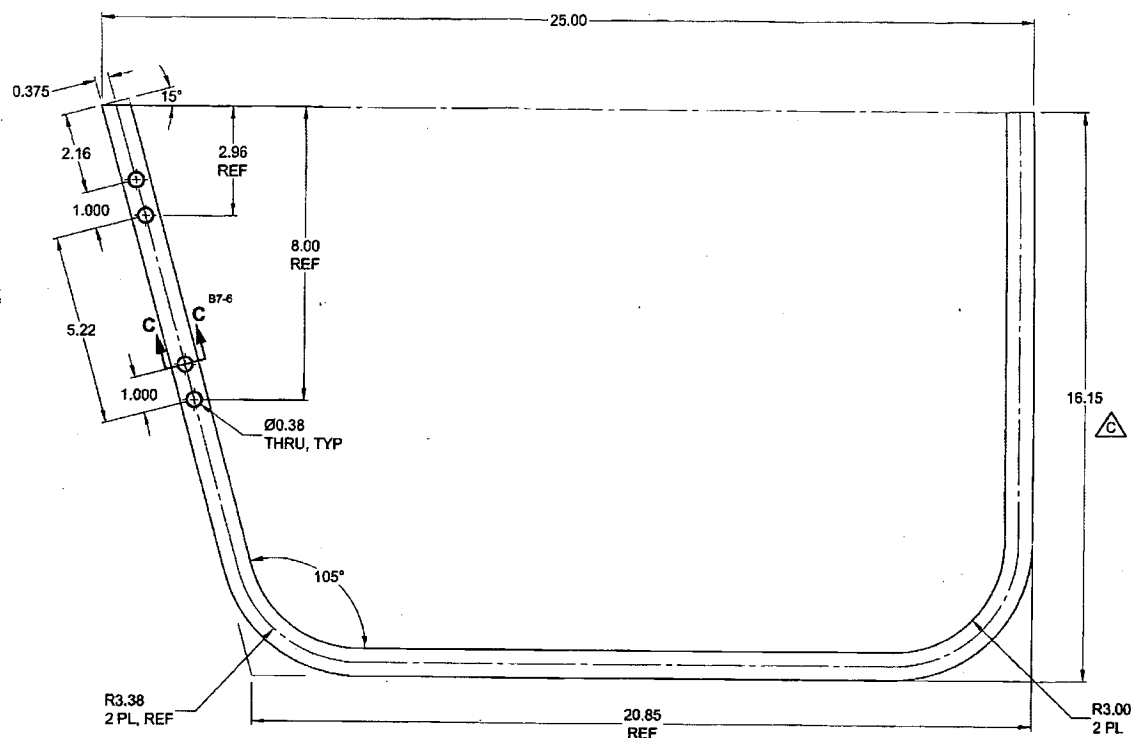
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.78 lbs
- 8) WELDING: PER DART QSI 004

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SECTION C-C
C6-6



8 D4306-4 RIB

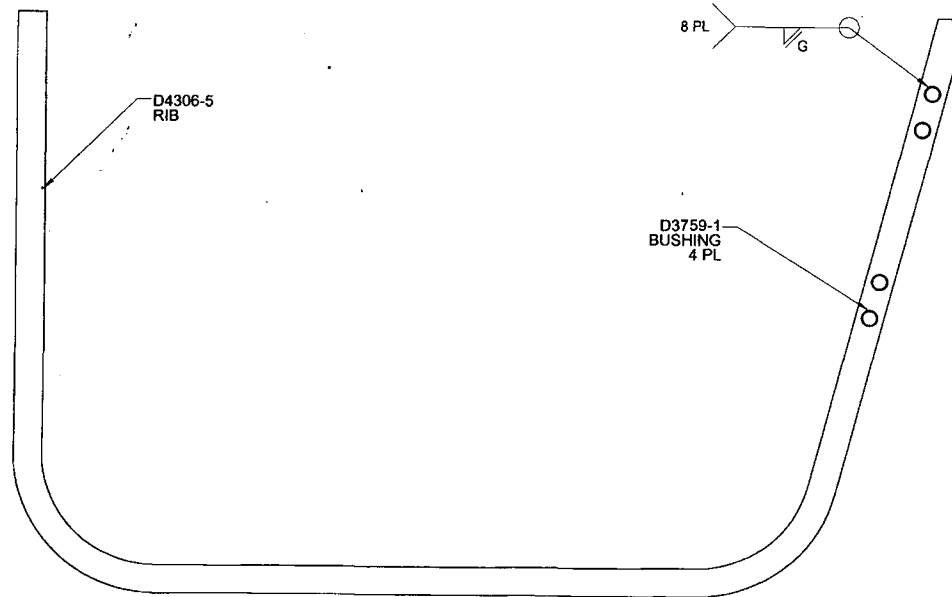
RELEASED
2011-02-20

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.049 WALL
REF DART SPEC. M304TS0.750W.049
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.78 lbs
- 8) TUBE FLAT LENGTH 52.0 REF

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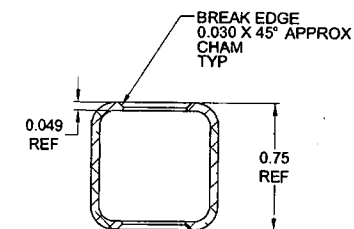
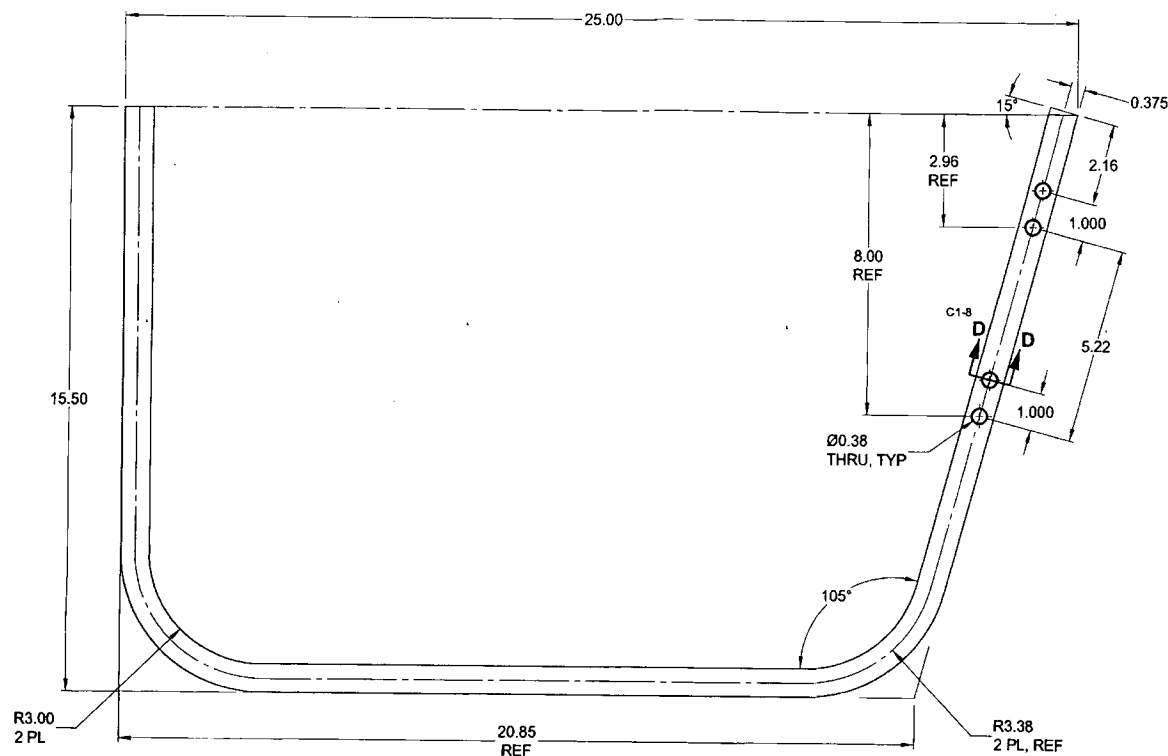
D4306-045 RIB ASSY

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2011-02-24
MD

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.78 lbs
- 8) WELDING: PER DART QSI 004

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SECTION D-D C3-8

D4306-5 RIB

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2011-02-24

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.049 WALL
REF DART SPEC. M304TS0.750W.049
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.78 lbs
- 8) TUBE FLAT LENGTH 50.0 REF

DESIGN	CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
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CHECKED	LS		DRAWING NO.	REV. C
MFG. APPR.	MS		D4306	SHEET 8 OF 8
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